

Work Order ID 84700

\*84700\*

Page 1

May-22-12 1:03:28 PM

Item ID: D3049-1

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Bearpaw

Start Date: 22/05/2012 Start Qty: 8.00

\*8\*

Cust Item ID:

Required Date: 05/06/2012 Req'd Qty: 8.00

\*8\*

Customer:

Reference:

Approvals: Process Plan: MLJ Date: 12/05/22

Tooling:

Date:

Run Start \*NR1\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3049	Rev A1					8		32	

110

0.00

\*110\*

Waterjet

Memo

0.00

FLOW CNC Waterjet

CUT BLANK AS PER FILE D3049-1 \_BLANK

R12-6-2

120

0.00

\*120\*

HAAS 1

HAAS CNC VERTICAL MACHINING #1

Memo

0.00

HAAS CNC vertical machine #1

1-Inspect material for defects or damage prior to machining  
2-Machine as per Folio FA165 and Dwg D3049 Identify as D3049-1  
3-Deburr

PO/B.A

12/07/06

8

0

R12-6-2

130

QC2- Inspect parts off machine FAI/FAIB

0.00

\*130\*

QC

Memo

0.00

Quality Control

PO/B.A

12/07/06

8

0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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**\*84700\***

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Item ID: D3049-1

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Item Name: Bearpaw

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Start Date: 22/05/2012 Start Qty: 8.00

**\*8\***

Cust Item ID:

Required Date: 05/06/2012 Req'd Qty: 8.00

**\*8\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

140 QC8- Inspect parts - second check

0.00

*B. P. 12/07/10*

**\*140\***

QC Memo

0.00

Quality Control

170 Identify as per dwg & Stock Location: \_\_\_\_\_

0.00

**\*170\***

Packaging Memo *PMP 84689*

0.00

Packaging

*P 12/7/5 8*

180 QC21- Final Inspection - Work Order Release

0.00

**\*180\***

QC Memo

0.00

Quality Control

*CK 12/7/10*

*MF 12-07-10*

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**NOTE:** Date & initial all entries

# Picklist Print

May-22-12 1:03:32 PM

Page 1

Work Order ID: 84700

\*84700\*

Parent Item: D3049-1

\*D3049-1\*

Parent Item Name: Bearpaw

Start Date: 22/05/2012

Required Date: 05/06/2012

Start Qty: 8.00

Required Qty: 8.00

## Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MUHMWB10		Purchased	No			120	sf	53.2100	3.4	27.2	35		
*MUHMWB10*									**				
UHMW 1" Black													

BIL-C-2

Location	Loc Qty	Loc Code
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MAT018	30.1	
120972	3	
121346	27.1	
MAT019	1.5	
118814	1.5	
ST052	21.60999474	
121277	12.8	
121278	8.80999474	

121851

121851

8

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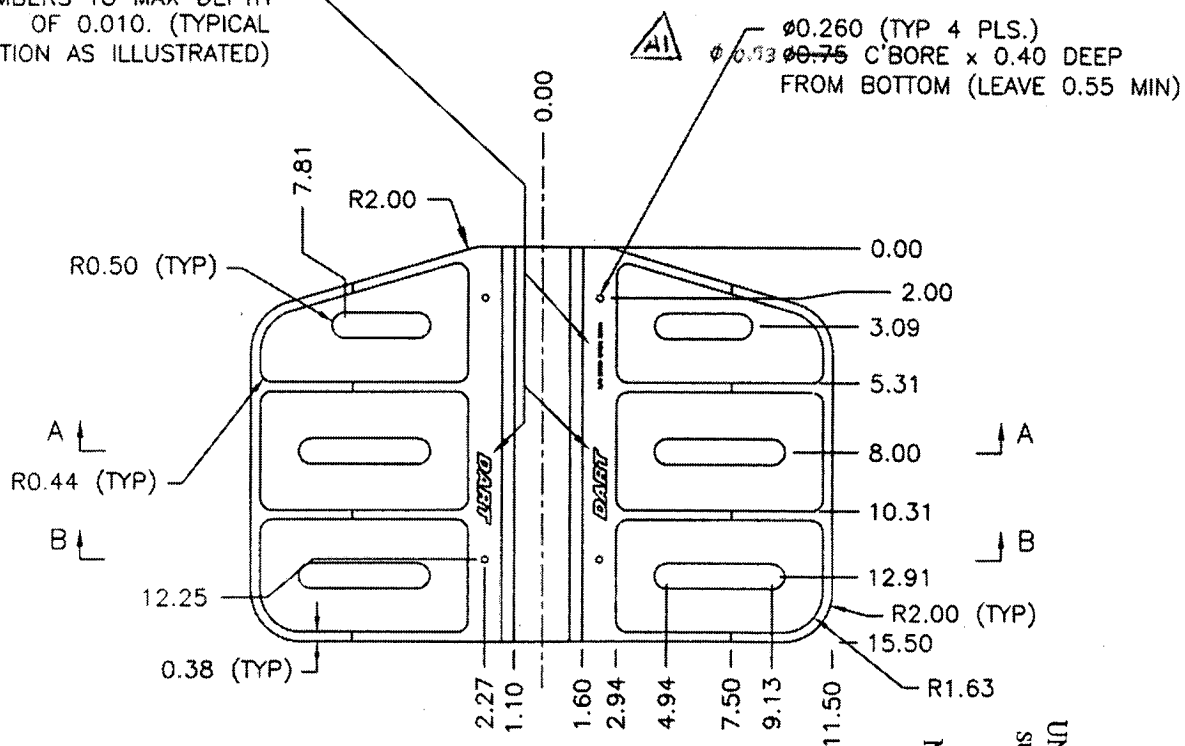
**NOTE:** Date & initial all entries



DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3049	REV. A SHEET 1 OF 2
DATE 01 10.18		TITLE BEARPAW	SCALE 1:7
A	01.10.18	NEW ISSUE	
AI	[Signature] 03.01.13	$\phi 0.73$ WAS $\phi 0.75$	

RELEASED  
01.10.24 [Signature]

ENGRAVE DART LOGO TO  
MAX DEPTH OF 0.012.  
ENGRAVE PART AND BATCH  
NUMBERS TO MAX DEPTH  
OF 0.010. (TYPICAL  
LOCATION AS ILLUSTRATED)



D3049-1 BEARPAW

NOTES:

- 1) BEARPAW IS SYMMETRIC ABOUT CENTER LINE
- 2) MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689  
1.00" THICK (MACHINE TO 0.950)

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 84700 M/L5  
12/05/22

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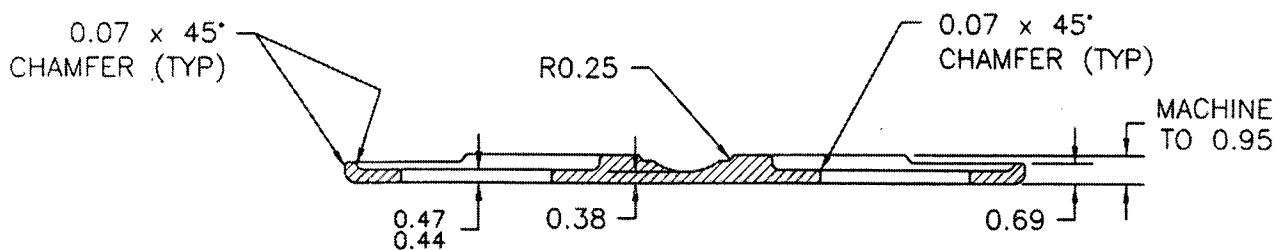
**NOTE:** Date & initial all entries



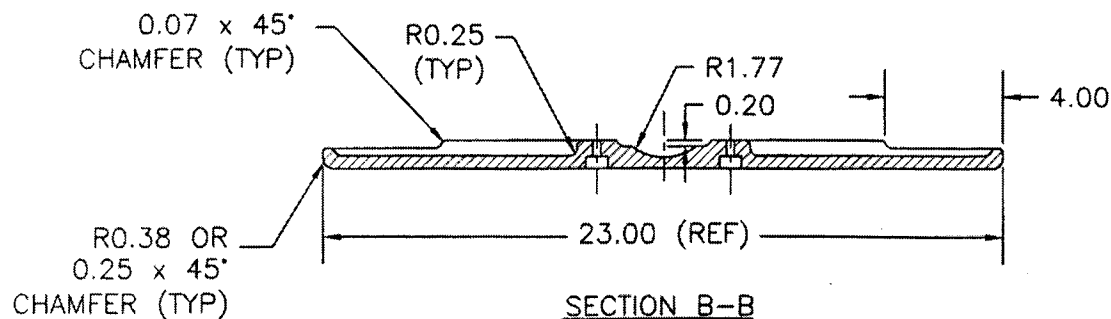


DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3049	REV. A SHEET 2 OF 2
DATE 01.10.18		TITLE BEARPAW	SCALE 1:6

RELEASED  
01.10.24 *[Signature]*



SECTION A-A



SECTION B-B

*20th*

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**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	
<b>Description:</b> Bearpaw		<b>Part Number:</b>	<b>D3049-1</b>
<b>Inspection Dwg:</b> D3049	<b>Rev:</b> A1	<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article**
☐ **Prototype**

Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	Ø0.260	+0.005/-0.000	0.260	✓		VERN	PHD-01
B	0.93	+/-0.030	0.931	✓		"	"
C	0.40	+0.030/-0.000	0.405	✓		MIC	PHD-09
D	2.00	+/-0.030	2.002	✓		VERN	PHD-01
E	10.250	+/-0.010	10.250	✓		H gauge	
F	4.540	+/-0.030	4.540	✓		VERN	PHD-01
G	5.88	+/-0.030	5.875	✓		"	"
H	0.38	+/-0.030	0.378	✓		"	"
I	11.50	+/-0.030	11.500	✓		M TAPE	PHD-11
J	0.07 x 45°	+0.030/-0.010	0.060	✓		VERN	PHD-01
K	0.44 - 0.47	+/-0.000	0.453	✓		MIC	118-120
L	R0.25	+/-0.030	0.250	✓		Rd gauge	
M	0.38	+/-0.010	0.376	✓		MIC	118-120
N	0.95	+0.030/-0.010	0.953	✓		VERN	PHD-01
O	0.69	+/-0.030	0.690	✓		"	"
P	0.20	+/-0.030	0.195	✓		MIC	PHD-09
Q	23.00	+/-0.030	23.000	✓		M TAPE	PHD-11
R	0.25 x 45°	+/-0.030	0.250	✓		VERN	PHD-01

<b>Measured by:</b> JD / B.A	<b>Audited by:</b> /st	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 12/07/06	<b>Date:</b> 12/07/06	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue P/O D135-692-011	KJ/RF	
B	08.05.06	Dimension I revised	KJ/DD	